Work Orde												Page 1
Item ID: Revision ID: Item Name:	D3135-041 D Handle Weldi	ment		Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	9/23/2009 10/9/2009	Start Qty: 4.00 Req'd Qty: 4.00	(1881) 2775 1881 1883 3081 1881		Cust Item I Customer:	D:		•				
Approvals:	Process Pla	an: Mm	Date:	Tooling: SPC (Y/N):	•	ate:	<u> </u>		Run	Start Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr				•						
Waterjet FLOW CNC Waterj	et	FLOW WATER JET Memo 1-Cut as p Deburr if	per Dwg D3135 3 □Dwg Re necessary	0.00 ev:□Prog Rev:_	▶ □2-				3 9-1	<u>4-3</u> C)	
110 QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				<u>i</u>	<u>\$</u> %	<u>9-3</u> C)	
120 		QC8- Inspect parts - s	econd check	0.00	57/07/30			E) —	<u>/</u>		· ——

13

Quality Control

Work Order ID 52370



Page 2

Tuesday, September 22, 2009 3:13:26 PM

Item ID:

D3135-041

Revision ID:

D Item Name: Handle Weldment

Required Date: 10/9/2009

Start Date:

9/23/2009

Start Oty: 4.00

Req'd Oty: 4.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop



Sequence ID/

Work Center ID

130

Small Fab Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

0.00

Draw Number

Plan Draw Code Rev.

Accept Oty

Reject **Qty**

Reject Number

Insp. Stamp

0.00 Memo

1-Bend D3135-1 as per template D3135-1T2 and Dwg D3135□2-Deburr ends



140

Quality Control

QC5- Inspect part completeness to step on W/O



150

Large Fab Large Fab

Large Fab

Memo

Memo

0.00

1-Weld handle onto plate as per Dwg D3135 and QSI 004 304 S.S. welding

rod Batch: M 109313

SM 09/10/01

Work Order ID 52370

Page 3

Tuesday, September 22, 2009 3:13:26 PM

Item ID:

D3135-041

D

Revision ID: Item Name:

Handle Weldment

Start Date:

9/23/2009

Start Qty: 4.00



Accept

Setup Start

Stop

Required Date: 10/9/2009

QC:

Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Tooling: Date:_____ Date:

SPC (Y/N):

Date:

Date:

Draw

Run Start

Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation **Description**

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Number

Draw

Rev.

Plan Code Accept Otv

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC5- Inspect part completeness to step on W/O

180

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

1100001 M

=> W 80/10/01

Memo

START TIME: 2 \3000 RFINISH TIME:

7\00pm oven temperature:

Work Order ID 52370

Page 4

Tuesday, September 22, 2009 3:13:26 PM

Item ID:

D3135-041

D **Revision ID:**

Item Name:

Handle Weldment

Start Date:

9/23/2009

Start Oty: 4.00

Required Date: 10/9/2009

Req'd Qty: 4.00



Date:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Draw

Number

Date:

Draw

Rev.

Run

Start Stop

Sequence ID/ Work Center ID

190

Operation **Description**

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00 m. 1 oul 10/01

Accept Qty

Plan

Code

Reject Qty

Reject Number

Insp. Stamp

Quality Control

200

Packaging

Packaging

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

09/10/05/1

Picklist Print

Tuesday, September 22, 2009 3:13:25 PM

Work Order ID: 52370

Parent Item:

D3135-041RevD

Parent Item Name:

Handle Weldment

Purchased

Comments:



Start Date: 9/23/2009

Required Date: 10/9/2009

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.375W.065		Purchased	No			100	f	67.7900	1.7545			
304 RD Tube .375 x .065W				***		-	٠.	T. C.L.				

	Warehouse	Loc Oty	Loc Code	
	Location			1 /
	Main Warehouse		MIN	09/09/30
	MAT	67.79		-
	111097	60	<u>M1110</u>	97
	18457	3.89		
	18993	3.9		
No		130 sf	205.2400 1.2632 1.5790	
				B4436

M304S16GA	

304/316 Sheet .063

<u>Warehouse</u>	Loc Oty	Loc Code
Location		
Main Warehouse		
MAT	205.2399737	

106860 16.018 25.1689737 111924 68.053 112442 112567 96

DART AEROSPACE LTD	Work Order: S2370
Description: HANDLE WEIDWENT	Part Number: 2333
Inspection Dwg: D3135-3 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø ,10	1,004 -,001	.104	کھ			
,50	4- ,020	.496	*	&		
. 68	4- 230	.680	*			
7.20	7030	7.200	7		·	
6.00	7- 220	6.005	*			
.063	4 .010	,061	*			
						,
				ļ		
				ļ		

Measured by:	IR	Audited by:	2	Prototype Approval:	N/A
Date:	9-9-30	Date:	09/09/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

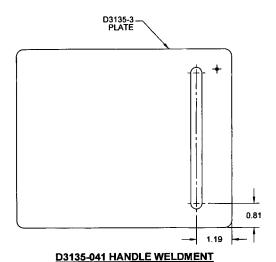
RESTRN TO I TORGETHER COLLY

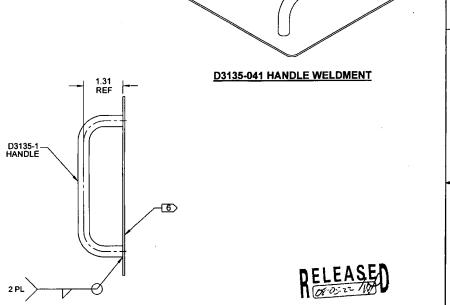
UNCONTROLLED COMY SUBJECT TO AMENDME: 1

WITHOUT NOTICE

RORK ORDER

QTY. -041 DESCRIPTION PART NUMBER х D3135-041 HANDLE WELDMENT HANDLE D3135-1 D3135-3 PLATE





DESIGN DS		DAPT AEPOSPA	CEL	Th	
REV.	DESCRIPTION			BY	DATE
Α	NEW ISSUE			DS	02.04.17
₿	6.400 WAS 6.330; ADD "ANNEALED"				03.03.04
С	REMOVED Ø0.221 HOLES				04.10.06
D	HOLE A	WN TO SOLIDWOR DDED. REASON: P G HOLE.	RKS FORMAT. ZN D4-2 TOOLING PRODUCTION REQUEST FOR	RJS	08.05.07

DESIGN	DS	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECKED	PH	DRAWING NO.	REV. D				
MFG. APPR.	42 0	D3135	SHEET 1 OF 2				
APPROVED	IN	TITLE	SCALE				
DE APPR.	4	HANDLE WELDMENT	NTS				
DATE 08.0	05.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS OF OWNERS OF CONTROL OF THE CONTROL OF					

D

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT COLOUR GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
7) WEIGHT: 0.90 lbs
8) WELD PER DART QSI 004

3

